

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006086**Date Inspected:** 28-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Fabrication**Summary of Items Observed:**

CWI Inspectors Mr. Chen Shou hua. Wu Ming Kai

On this date CALTRANS OSM Quality Assurance (QA) Inspector Mr. Paul Dawson arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Bay 2

Caltrans QA Inspector Mr. Larry Viars informed this QA Inspector he had observed a class "A" ultrasonic indication in floor beam weld FB24-002-015. This QA Inspector performed ultrasonic (UT) inspections of this same weld and confirmed the weld appears to have a class "A" ultrasonic indication. The QA Inspector informed ZPMC QC representative Mr. Testino that floor beam weld FB24-002-015 had been ultrasonically accepted by ZPMC Inspection personnel and that the weld appears to be rejectable. Later in the day Mr. Testino informed the QA Inspector that ZPMC ultrasonic Inspectors have confirmed the weld is rejectable and that the weld will be repaired.

T.Y. Lin International Engineering requested assistance on evaluation of FCN 119 - RFI 1474R1 concerning welder access on corner assemblies CR-105 through CR-108. This QA Inspector performed measurements, obtained photographs and submitted relevant information to the Engineers. Below is a copy of the information that was provided.

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“Below are photographs showing the partial penetration weld joint clearance dimensions of CA108 as taken in OBG Bay #2. These dimensions typical for all four components are in reference to FCN-119 and RFI 1474R1. Per discussion between QA Inspector Paul Dawson and QC representative Mr. Wang Jie on February 28, ZPMC is not going to commence fitup of any of the partial penetration joints on CA-105, CA-106, CA-107 and CA-108 until Sunday March 1 or Monday March 2, 2009.

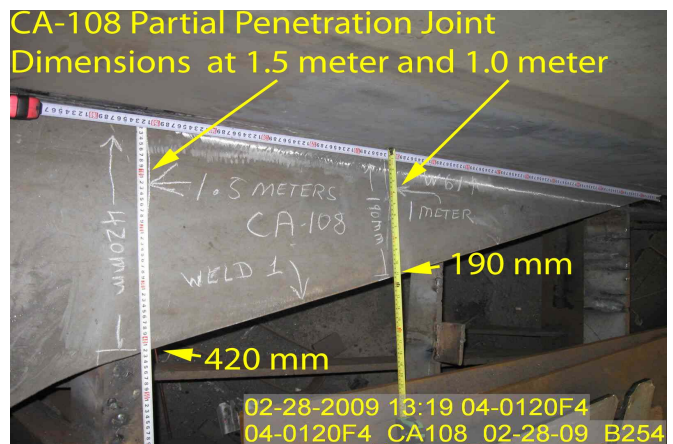
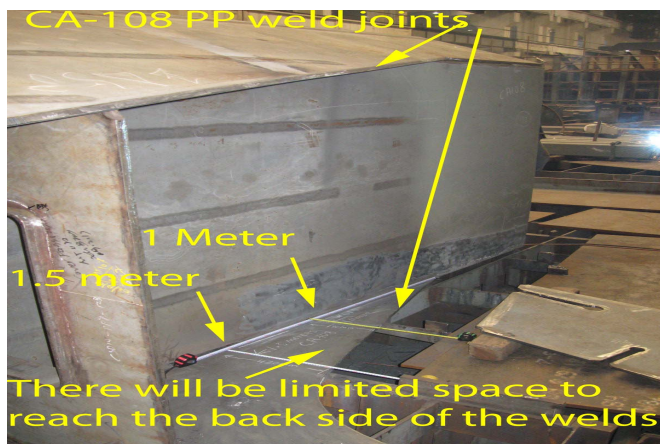
Visual inspection revealed the partial penetration weld joints have previously been beveled and no ZPMC personnel were working on these weld joints.

At a distance of 1 meter from the end of the partial penetration weld the clearance between the existing plate and the new plate that is going to be installed (weld #1) is approximately 190 mm and at 1.5 meters the clearance is approximately 420 mm.”

Tower Bay 10

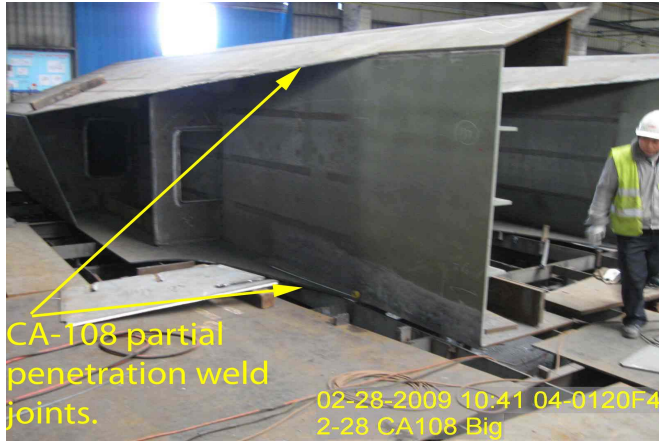
The QA Inspector observed ZPMC welder Ms. Zhang Lingling stencil 207746 is using welding procedure specification WPS-B-T-2221-B-S2 to make submerged arc groove weld NSD1-FDSA3-1B/C-9A. ZPMC QC Inspector Mr. Chen Sha Hua was monitoring this welding. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Ms. Liu Xiaoyan stencil 207745 is using welding procedure specification WPS-B-T-2221-B-S2 to make submerged arc groove weld NSD1-FDSA3-1B/C-6A. ZPMC QC Inspector Mr. Chen Sha Hua was monitoring this welding. Items observed by the QA Inspector appear to comply with project specifications



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Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod phone: 134-8257-0045 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
